

Work Order ID 66646

Wednesday, February 23, 2011 1:08:32 PM



Page 1

Item ID: D3529-1

Accept



Setup Start



Revision ID:

Item Name: Bearpaw

Stop



Start Date: 2/23/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/4/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: CS Date: 11/02/23 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3529	Rev A								
110		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	CUT BLANK AS PER FILE D3529-1BLANK								
								(4)	
120		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Inspect material for defects or damage prior to machining 2-Machine as per Folio FA645 and Dwg D3529 3-Deburr								
130		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

B 11-3-1

(4)

JL 11/03/14

(5)

(ITC) →

JL 11/03/14

(5)

Batch
Prod:

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 3529-1 PAR #: _____ Fault Category: Unloading NCR: Yes No DQA: _____ Date: 11/03/15
 Resolution: 3crw Disposition: scrap QA: N/C Closed: _____ Date: 11/3/15

NCR: 66646		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/03/14	120	- 1 part has deep marks in low area caused by malfunction of "Z" motor on H451.	<i>[Signature]</i> 12/1/14	- scrap replace - machine has been serviced.	<i>[Signature]</i> 11/03/14	G.A 11/03/15	<i>[Signature]</i> 12/1/14	<i>[Signature]</i> 11/03/15
		R.C. machine malfunction	<i>[Signature]</i> 12/1/14	- Record on maint log that machine has been serviced ? Ref this NCR	<i>[Signature]</i> 11/03/14	G.A 11/03/15	<i>[Signature]</i> 12/1/14	<i>[Signature]</i> 11/03/15

NOTE: Date & initial all entries

Work Order ID 66646

Wednesday, February 23, 2011 1:08:33 PM

Page 2

Item ID: D3529-1

Accept

Revision ID:

Item Name: Bearpaw

Start Date: 2/23/2011 Start Qty: 4.00

Required Date: 3/4/2011 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

B.A 11/03/15

5

0

150

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

PPP 66646

C4/3/15

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/15

C2 11/03/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, February 23, 2011 1:08:28 PM

Page 1

Work Order ID: 66646



Parent Item: D3529-1



Parent Item Name: Bearpaw



Start Date: 2/23/2011

Required Date: 3/4/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 06-06-28 JLM
IPP Rev:B New Manufacturing Method 08-11-27 Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10 		Purchased	No			100	sf	368.1000	1.265	5.326316			
											Bill-3-1		

UHMW 1" Black

Location

Loc Qty

Loc Code

MAT

368.1

115955

38.8

116554

108.3

116796

18

116797

203

116796

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

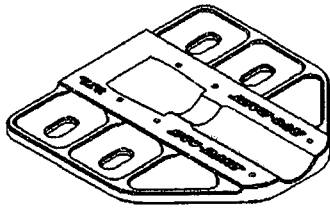
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

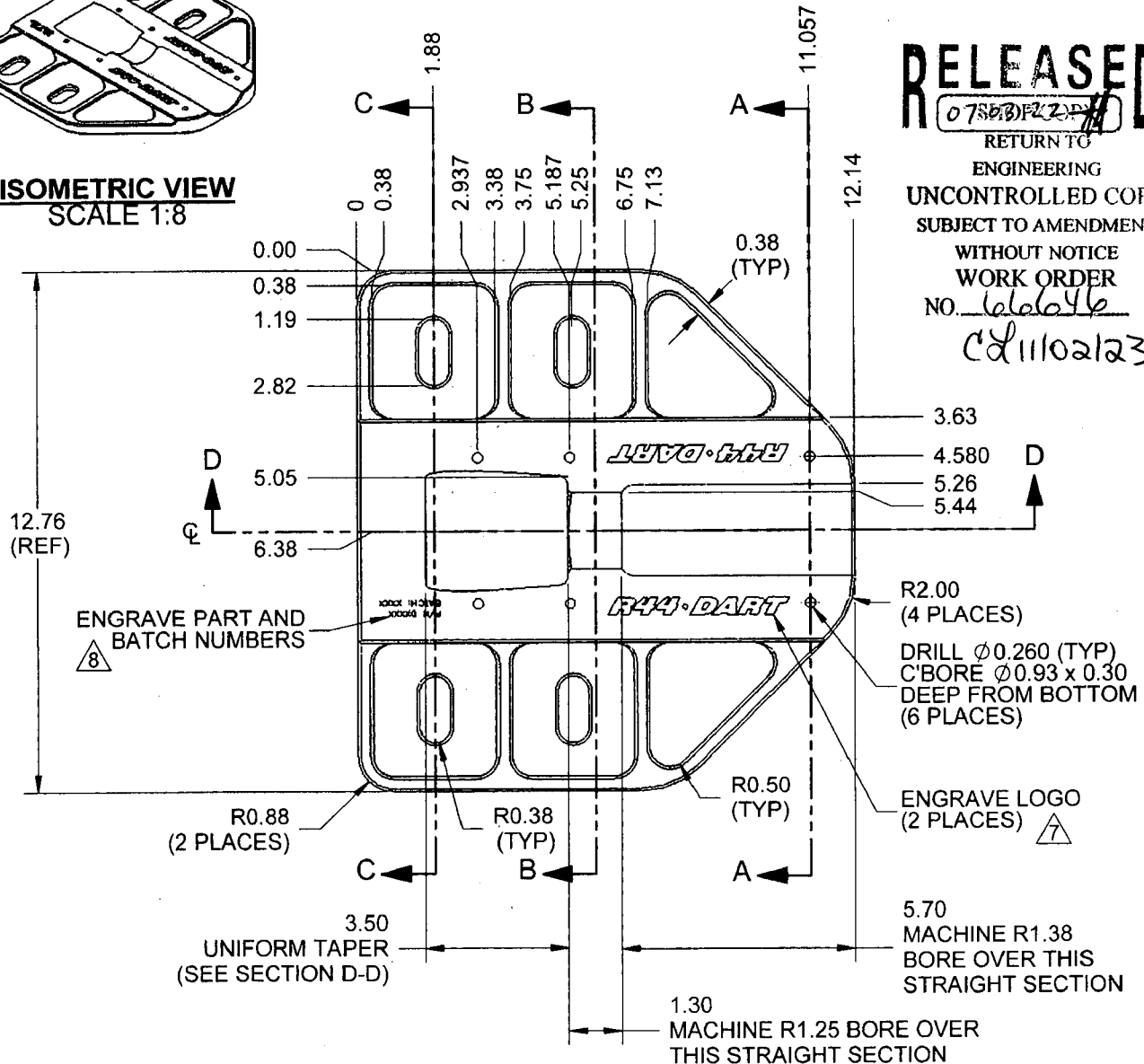
NOTE: Date & initial all entries

DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3529	REV. A SHEET 1 OF 2
DATE 07.01.04	TITLE R44 BEARPAW		SCALE 1:4
REV A	DATE 07.01.04	DESCRIPTION NEW ISSUE	



ISOMETRIC VIEW
SCALE 1:8



RELEASED
073803P22P1

RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **666646**
C211102123

D3529-1 R44 BEARPAW

NOTES:

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
- 3) PART IS SYMMETRIC ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) ENGRAVE LOGO TO MAX DEPTH OF 0.012 AT LOCATION SHOWN
- 8) ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010 AT LOCATION SHOWN

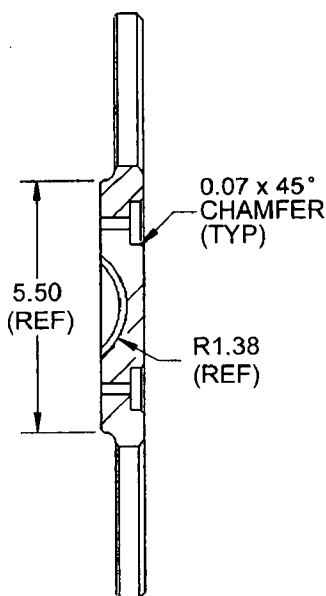
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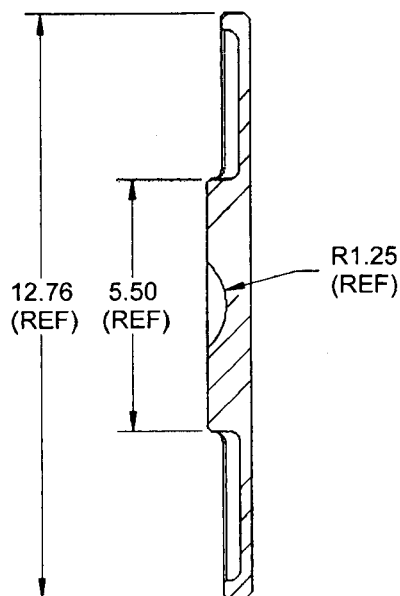


DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3529
DATE 07.01.04	TITLE R44 BEARPAW	REV. A SHEET 2 OF 2 SCALE 1:4

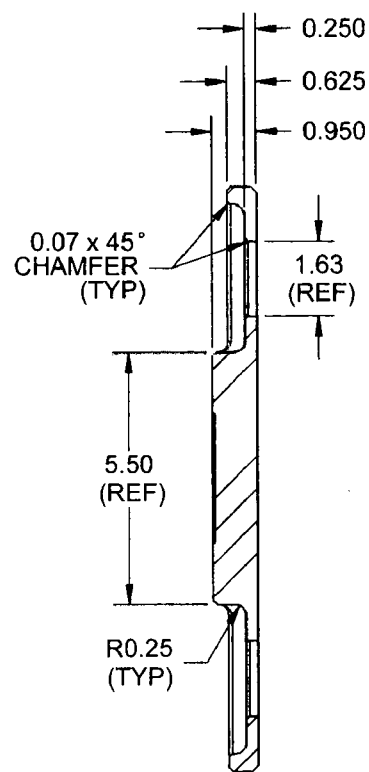
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07.03.22



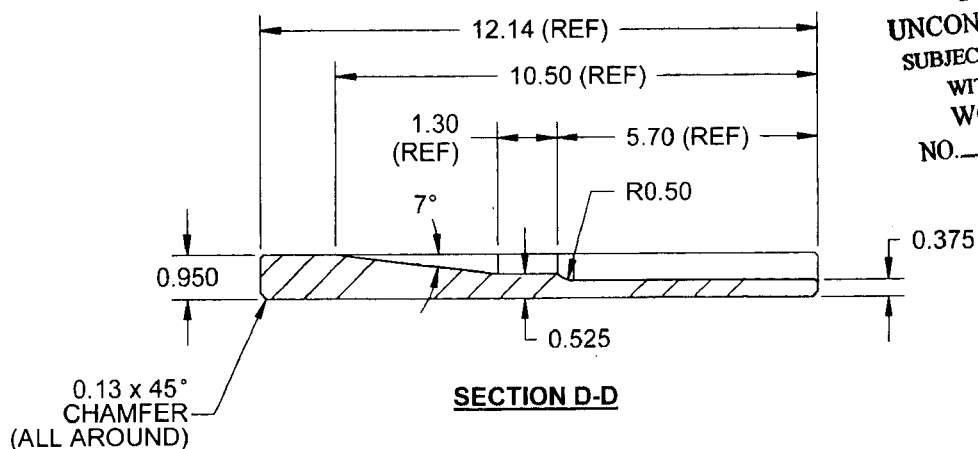
SECTION A-A



SECTION B-B



SECTION C-C



SECTION D-D

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NO. *66646*

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DART AEROSPACE LTD		Work Order:	66646
Description: Bearpaw		Part Number:	D3529-1
Inspection Dwg: D3529 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	5.50	+/-0.030	5.505	/		VER 21.3	
B	0.07 x 45°	+/-0.030 x 0.5°	0.07 x 45°	/			
C	R0.25	+/-0.030	250	/		R-G	
D	0.250	+/-0.010	245	/			
E	0.625	+/-0.010	624	/			
F	0.950	+/-0.010	947	/			
G	1.63	+/-0.030	1.620	/			
H	12.14	+/-0.030	12.14	/		m-tape	
I							
J	5.70	+/-0.030	5.70	/			
K	0.375	+/-0.010	378	/			
L	0.525	+/-0.010	525	/		mic 118-120	
M	0.13 x 45°	+/-0.030 x 0.5°	150 x 45°	/			
N	R0.50	+/-0.030	50	/		R-G	
O	12.76	+/-0.030	12.760	/		m-tape	
P	3.38	+/-0.030	3.378	/			
Q	3.75	+/-0.030	3.752	/			
R	5.187	+/-0.010	5.188	/			
S	5.25	+/-0.030	5.250	/			
T	7.13	+/-0.030	7.131	/		VER CNC-02	
U	Ø0.260	+0.006/-0.001	260	/			
V	0.30	+/-0.030	312	/			
W	0.93	+/-0.030	924	/			
X	1.30	+/-0.030	1.30	/			

Measured by:	SL	Audited by:	A.A	Prototype Approval:	N/A
Date:	11/03/14	Date:	11/03/15	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.01	New Issue	KJ/JLM	
B	08.05.06	Dimension I removed	KJ/DD	